

Work Order ID 75081

75081

Page 1

October-17-11 10:51:21 AM

Item ID: D2348 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate
 Start Date: 17/10/2011 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 28/10/2011 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/17 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2348	Rev C								

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.00
 FLOW CNC Waterjet
 6061 .063
 1-Cut as per Dwg D2348
 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00
 Quality Control

B11-11-21

(23)

B11-11-21

11. 11. 22 (23)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
150									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O: <u>15506</u> Black Anodize per Dwg D2348 Ensure Certificate of Conformity is attached								<u>CL 11/11/22 23</u>
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								<u>P 11/11/15 (23)</u>
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control	INSPECT CERTS								<u>counts</u> <u>(23)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Small Fab	0.00							
180									
Small Fab	Memo	0.00							
Small Fab	Install Insert as per Dwg D2348								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>ST 7</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									

Handwritten: 12/01/24 (23)

Handwritten: conto (23)

Handwritten: (23) SP 12-01-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

12/11/25 *[Signature]*
mf
12-01-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-17-11 10:51:26 AM

Page 1

Work Order ID: 75081

75081

Parent Item: D2348

D2348

Parent Item Name: Wearplate

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

115.8856

0.0198

0.416842

(1

M6061T6S 063

6061-T6 .063 Sheet

**

13111-21

Location

Loc Qty

Loc Code

MAT021

115.8855684

116308

26.9755684

117285

88.91

D3996-FE-832-EF

Manufactured

No

180

Each

91.0000

4

80

D3996-FE-832-EF

Self-Clinching Fastener

**

Location

Loc Qty

Loc Code

ST285

91

71756

91

30

B 77489

(620)

12/01/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

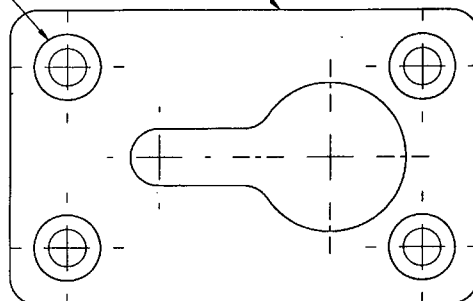
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D2348	WEAR PLATE
2	1	D2348F	FLAT PATTERN
3	4	D3996-FE-832-EF	SELF-CLINCHING FASTENER

D3996-FE-832-EF
SELF-CLINCHING FASTENER
4 PL

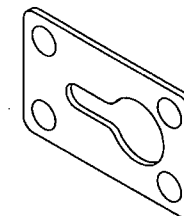
D2348F



D2348 WEAR PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75081

PIE 10-17

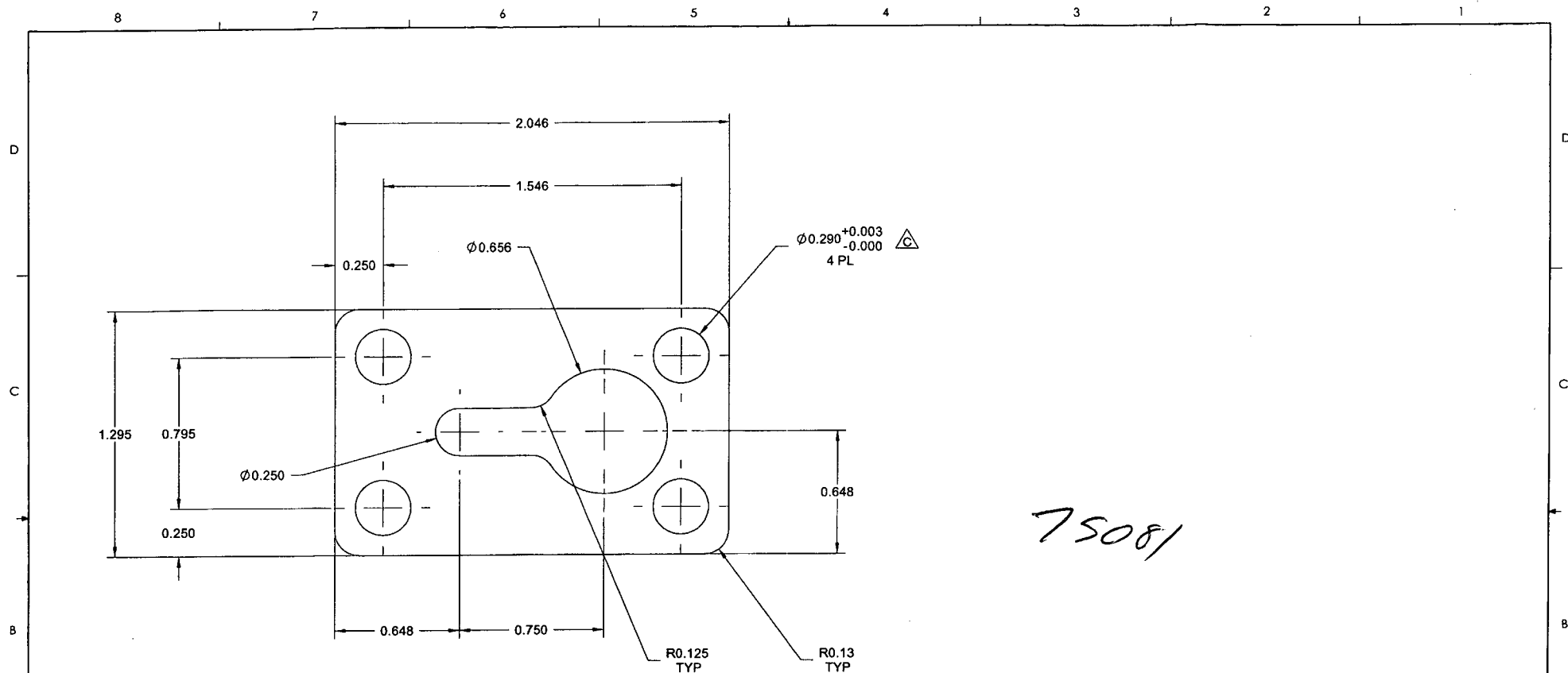


RELEASED
2009-11-09
MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348" USING REMOVABLE TAG
- 7) WEIGHT: 0.01 lbs

C	REDRAW, ADD +0.003/-0.000 TOL (ZN D4-2), NCR 08-042	CP	09.10.01
B2	CHANGED BACK TO 6061-T6	DS	02.02.21
B1	CHANGED TO AISI 304/316 MATERIAL	DS	00.03.07
B	CHANGED PEM INSERT TO B-32	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>GP</i>		
CHECKED	<i>B</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>B</i>	D2348	SHEET 1 OF 2
APPROVED	<i>B</i>	TITLE	SCALE
DE APPR.	<i>B</i>	WEAR PLATE	NTS
DATE	09.10.01	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D2348F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/II/III/IV CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348F" USING REMOVABLE TAG
- 7) WEIGHT: 0.01 lbs

RELEASED
2009-11-08

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MD	DRAWING NO.	REV. C
MFG. APPR.	MD	D2348	SHEET 2 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	WEAR PLATE	NTS
DATE	09.10.01	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15506

Purchase Order Date 11/22/11

PO Print Date 1/04/12

Page Number 1 of 2

Order From :

VC-AND002

ANODIZING & PAINT T.N.M. INC.
21 AVIATION ROAD
POINTE CLAIRE, QC H9R 4Z2
CA

Contact Name

Vendor Phone

514 429 7777

Vendor Fax

514 429 5108

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

RECEIVED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
2	76529	D4410-3 FACE PLATE	1/06/12 Yes	3.00	FedEx PI collect	\$1.6000	\$4.80
		Special Inst:	D4410-3 BLACK ANODIZE B76529 ANODIZE PER MIL-A-8625F TYPE I/IB/IC/II OR IIB CLASS 2				
3	75081	D2348 WEARPLATE	1/06/12 Yes	23.00	FedEx PI collect	\$1.6000	\$36.80
		Special Inst:	D2348 BLACK ANODIZE B75081 ANODIZE PER MIL-A-8625F TYPE I/IB/IC/II OR IIB CLASS 2				
4	75829	D1038-58B FASTENER RAIL	1/06/12 Yes	50.00	FedEx PI collect	\$1.6000	\$80.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 4

Change Date: 1/04/12



SHIPPING ADVICE BON DE LIVRAISON



C of C Number : 209436

Customer
DART AEROSPACE
1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 TEL # 613-632-9577 FAX # 613-632-1053

Shipping Address
1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 TEL # 613-632-9577 FAX # 613-632-1053

PO Number: P015506	Cert Rev: 0	Ship date: 2012-01-18	C of C Generator: Waqas
--------------------	-------------	-----------------------	-------------------------

LINE ITEM DETAIL - PARTS DESCRIPTION									
Item #	Part Number	Dash	Serial Number	Lot/Batch Number	PO Line Item #	Rec	Rej	Ship	Additional Information
1	TEmples BLACK ANODIZE MIL-8625				001	3	0	3	Refer to C of C for specific details
2	TEmples BLACK ANODIZE MIL-8625				002	23	0	23	Refer to C of C for specific details
3	TEmples BLACK ANODIZE MIL-8625				003	50	0	50	

Transport/FOB Point:	
----------------------	--

I hereby take possession of the goods mentioned above and acknowledge that parts are packaged properly and no visual damage is apparent on parts / Packaging.
Je prends possession des biens ci-haut mentionnés et confirme que les pièces ont été emballées de façon adéquate et ne présente pas de dommage apparent aux pièces / emballage.

Signature: _____ Date: _____



CERTIFICATE OF CONFORMITY CERTIFICAT DE CONFORMITÉ



C of C Number :		209436	
Cert Rev	0	DWG Rev	
Page:	1 of 1		
C of C date	18 Jan 2012		
PO Number :	PO15506		

Customer
DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 TEL # 613-632-9577 FAX # 613-632-1053

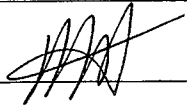
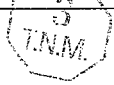
S. 26/170

C of C Generator	Waqas
Material	

LINE ITEM DETAIL - PARTS DESCRIPTION									
Item #	Part Number	Dash	Serial Number	Lot/Batch Number	PO Line Item #	Rec	Rej	Ship	Additional Information
1	TEmpLates BLACK ANODIZE MIL-8625				001	3	0	3	76529/D4410-3, FACE PLATE
2	TEmpLates BLACK ANODIZE MIL-8625				002	23	0	23	75081/D2348
3	TEmpLates BLACK ANODIZE MIL-8625				003	50	0	50	D1038-58B

THE FOLLOWING PROCESS(ES) WERE APPLIED TO THE COMPONENTS MENTIONNED ABOVE				
#	Required Process Name	Spec Number	Rev.	Process description
1	Sulphuric Acid Anodize Per MIL-A-8625 BLACK	MIL-A-8625	F, AMENDMENT 1	BLACK ANODIZE PER MIL-A-8625 rev F1 TYPE II CLASS 2

Customer Additional Info:	
<p>This certifies that all parts are processed, tested and inspected to the requirements of the above requirements / Specification. Travel Card have been completed, filed and are available for review upon request.</p> <p>Nous certifions que les Pièces énumérées ci-haut ont été traitées et inspectées selon les requis / Spécifications mentionnés. Les feuilles de Route (Travel card) ont été complétées, classées et sont disponibles pour consultation sur demande.</p> <p>Importante Notice: Painted Parts will be Fully Solvent Resistant after 7(seven) Full Days of Air Curing at Ambient Temperatures. Any modification/Rework to the components without express written agreement from TNM will invalidate this certificate.</p> <p>Notice importante: Les pièces peintes seront complètement résistantes au solvant après 7(sept) jours complets de séchage à l'air ambiant. Quelques Modifications / Réparations que ce soit, faites aux composantes, sans le consentement écrit de TNM invalideront ce Certificat.</p>	

Signature:  Stamp:  Date: *Jan 18, 2012*

Template Name/Rev: Certificate of Conformity Rev X